: WEB ASSEMBLY

: D2174041

: 4/4/2008

: N/A

: E

D2174 REV E

Date:

Tuesday, 3/11/2008 7:57:21 AM

User:

Kim Johnston

Process Sheet

Drawing Name

Part Number

Material **Due Date**

Description:

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Type

S.O. No. :

Job Number : 10194 **Estimate Number**

: 37741

P.O. Number

This Issue

: 3/11/2008

: NC

: // First Issue

Previous Run

Prsht Rev.

: 32856

Written By

Comment

Checked & Approved By

Reformat; Changed Step 2 KJ/JLM : Est: D 04:06:10

Est Rev:E As per Rev E 06-11-22 JLM

: SMALL /MED FAB

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Web

1.0 D21741



Comment: Qty.:

1.0000 Each(s)/Unit

10.0000 Each(s) /2 Total:

Web

Qty Part Number D2174-1

Description Batch

Web

Angle LH

Comment: Qty... 1.0000 Each(s)/Unit Total:

D21751

Angle LH

Description

Qty Part Number

D2175-1

Angle

Batch 31691

10.0000 Each(s) /2

B37848

3008/04/01

(PL)

12

Each

3.0

2.0

D21752

Comment: Qty.:

1.0000 Each(s)/Unit

Total:

10.0000 Each(s)

Angle RH

Qty Part Number

D2175-2

Description

0803

4.0

MS20470AD46

Angle

Rivet, Universal Head

Comment: Qty.:

19.0000 Each(s)/Unit

Total: 190.0000 Each(s) 228 Rivets

m 107082

Rivet, Universal Head

Qty Part Number

MS20470AD4-6

Description

Rivet

M106375 x13

Page 1

Form: rorocess

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W/O:		V	VORK ORDI	R CHANGES					
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Part No:	PAR #:	Fault Ca	tegory:	N				_ Date:	2.
NCR:	W	ORK OR	DER NON-C	ONFORMANO	E (NCF	R)			
DATE STEP	Description of NC Section A	Initial Chief Eng	Corrective A	ction Section B Description thief Eng	Sign &	Verifica Sectio		Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial/all entries

Tuesday, 3/11/2008 7:57:21 AM Date: User: Kim Johnston **Process Sheet** Drawing Name: WEB ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Job Number: 37741 Part Number: D2174041 Job Number: Seq. #: Description: Machine Or Operation: SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 5.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Assemble as per Dwg D2174-041 2- Identify as D2174-041 INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP POWDER COATING POWDER COATING m 107550 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSI Comment: INSPECT POWDER COAT Screw Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s) Screw Batch: 10.0 AN960JD8 Washer Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s) Washer Batch: 11.0 MS21042L08 Nut Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s) Nut M106903 Batch: 12.0 SMALL FAB SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Install nuts & bolts loosely as per Dwg D2274

Dart Aerospace Ltd

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W/O:			V	ORK ORDER CI	HANGES	· · · · · · · · · · · · · · · · · · ·				<u> </u>		
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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Part No	•	PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQ	\:	_ Date: _			
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NCR:			WORK OR	DER NON-CONF	ORMANCI	E (NCR)					
DATE	STEP	Description of NC Section A	Initial	Corrective Action Action Descr		Sign &	Verific Section		Approval Chief Eng	Approval QC Inspector		
			Chief Eng	Chief Eng		Date						
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NOTE: Date & initial all entries

Date:

Tuesday, 3/11/2008 7:57:21 AM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB ASSEMBLY

Job Number: 37741

Part Number: D2174041

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



14.0

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

QC21

FINAL INSPECTION/W/O RELEASE



15.0



Comment: FINAL INSPECTION/W/O RELEASE



Job Completion



u 08-04-04

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W/O:			WO	RK ORDER CHANG	3ES					
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NOTE: Date & initial all entries



D2175-2 ANGLE

D2175-1 ANGLE

/E/

DESIGN TO	DRAWN BY	HAWKESBURY, ONTARIO, CANADA
CHECKED.	APPROVED	DRAWING NO. REV. E
L	f	D2174 SHEET 1 OF 2
DATE		TITLE SCALE
06.09.25		WEB ASSEMBLY 1:3
A	95.10.25	NEW ISSUE
В	96.01.18	RE-DRAWN
С	00.09.11	UPDATE FINISH SPEC.
ם	04.06.03	RE-DESIGN
П	06.09.25	INC 4 HOLES TO Ø0.172; CHG HARDWARE

	D2174-1	\big \cdot
	MS20470AD4-6 RIVET (19 PLS) AN526CB32R14 SCREW (AN960JD8 WASHER (1) MS21042L08 NUT (1)	[1)
077/	INSTALL LOOSE OPEN OF THE PROPERTY OF THE PR	

UNCONTROLLED COPY

ENGINEERING

SHOP COPY RETURN TO

SUBJECT TO AMENDMENT

WITHOUT NOTICE

QTY DESCRIPTION P/N -041 D2174-041 WEB ASSEMBLY X WEB D2174-1 D2175-2 **ANGLE** 1 D2175-1 ANGLE AN526C832R14 **SCREW** 4 AN960JD8 WASHER 4 MS21042L08 NUT 19 MS20470AD4-6 RIVET

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

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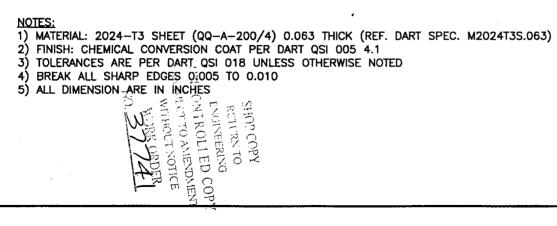
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06.09.25

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WEB 1:3		
TITLE SCALE		- 1
D2174 SHEET 2 OF 2	*	
DRAWING NO. REV. E	APPROVED	
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	DRAWN BY	

-	6.250
R0.35 (TYP) —	
+	3.012 1.529 E (1.506 PITCH) Ø0.172 (4 HOLES)
4.283 0.500	R0.13 4.800
2.692	DIRECTION 6.400
0.900	50° (TYP)
1	Ø0.128 (22 HOLES)
1.075	10.500 (1.050 РПСН) L_0.300 L_1.375
0.550	11.550 (1.050 PITCH)

D2174-1



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